User:

Thursday, 31/07/2008 12:18:10 PM

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number

: 40854 : 10425

Estimate Number

P.O. Number

This Issue

: 31/07/2008

: NC Prsht Rev.

: // First Issue

: 39262 **Previous Run**

Written By

Checked & Approved By

Comment

A04.04.19

: SMALL /MED FAB

ESR B 06.05.25

Wateriet

Drawing Name

: PLATE

Part Number

Due Date

Drawing Number

: D32191 . D3219 REV A

Project Number

: N/A

Drawing Revision

Material

: 11/08/2008

Qty:

100 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 .125 Sheet

1.0

M6061T6S125

Comment: Qty.:

10.1220 sf(s)

6061-T6 .125 Sheet

To be made in multiples of 4

0.1012 sf(s)/Unit

Material: 6061-T6 (QQ-A-200/11) 0.125" thick

(M6061T6S.125) Batch: 108659

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3219

Dwg Rev:

Prog Rev:

1B 8-8-13



3.0

INSPECT PARTS AS THEY COME OFF MACHINE



B8-8-13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

Comment: SECOND

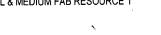
5.0

SMALL FAB 1

SECOND CHECK

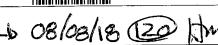


SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.



Dart Ae	rospace	∍ Ltd							
W/O:			ν	VORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·
Part No	:	PAR #:	Fault Ca	tegory: NC	R: Yes	No DQ	A:	Date: _	
					QA: I	N/C Close	d:	Date: _	
NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCI	₹)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign a	Secti	cation ion C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Thursday, 31/07/2008 12:18:10 PM Date: User: Julie Lecocq **Process Sheet Drawing Name: PLATE** Customer: CU-DAR001 Dart Helicopters Services Part Number: D32191 Job Number: 40854 Job Number: Description: Seq. #: Machine Or Operation: INSPECT, WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

	WORK ORDER C	HANGES							
STEP	PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			 	<u> </u>					
	STEP	STEP PROCEDURE CHANGE		STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr			

QA: N/C Closed: _____ Date: _____

		WORK ORD	DER NON-CONFORMANO	CE (NCR)					
	Description of NC		Corrective Action Section B			Ammana			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto		
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 40854
Description: Plate	Part Number: D3219-1
Inspection Dwg: D3219 Rev: A	Page 1 of 1

	X.	First Arti	cle	_ Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
Ø0.316	+0.005/-0.000	-30) ±				
2.293	+/-0.005	7.291	×				
2.965	+/-0.010		961 🗶				
0.566	+/-0.010	iSlela	> ₽				
0.375	+/-0.010	315	L				
R0.125	+/-0.010	7125	*				
13.9°	+/-0.5°	13.90	×				
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				1			

Measured by: 12	Audited by:		Prototype Approval:	N/A
Date: 88-43	Date:	1060618	Date:	N/A

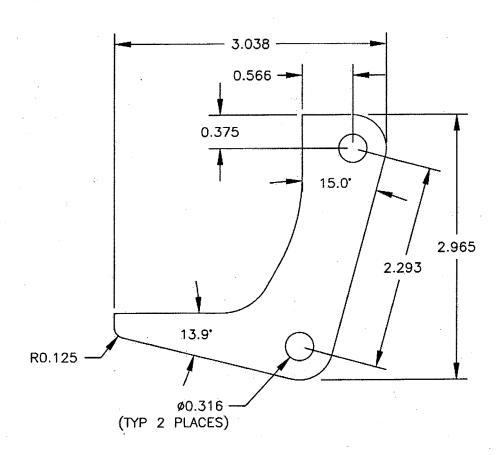
Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue	KJ/JLM	
В	07.09.06	13.9° dimension added	KJ/JLM	
С	08.04.15	0.125 dimension removed	KJ/DD	<i>M</i>





•		No. 1 to the second sec				
DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED,	DRAWING NO.	REV. A			
#	The second second	D3219	SHEET 1 OF 1			
DATE		TITLE	SCALE			
03.10.10		PLATE	1:1			
Α	03.10.10	NEW ISSUE				





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11) (REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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